

Date: Monday, 9/10/2007 1:18:58 PM  
 User: Kim Johnston

## Process Sheet

*Split 2*

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ARM
Job Number	34475		
Estimate Number	12882		
P.O. Number	N/A	Part Number	D3560042
This Issue	9/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3560 UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	32645	Drawing Revision	B/C
Written By		Material	N/A
Checked & Approved By		Due Date	9/17/2007
Comment	Est Rev:A New Issue 07.05.24 EC	Qty:	58
Um:			PC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
	Comment: Qty.: 1.4648 f(s)/Unit Total : 17.5770 f(s) 6061-T6 Bar 0.50" x 5.00" Batch: H105646	<i>JNL 07/09/20</i>
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blanks 16.750" long	<i>JNL 07/09/20</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	

1- Mill as per Folio FA694 Rev: A & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*JL 07/09/21*

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*JL 07/09/21*



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Process Sheet

SPLIT-2

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34475

Part Number: D3560042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D35921

PLATE



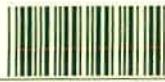
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

PLATE 334260

334478 5 01-10-25 01-10-10

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

01-10-25 5 01-10-10

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

01-10-26 5

9.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

01-10-26 5

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

01-10-26 5

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

01-10-26 5

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

01-10-26 5

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WHT

01-10-26 5



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34475

Part Number: D3560042

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

10/10/06

Job Completion



W 10/10/06



DART AEROSPACE LTD	Work Order:	34475
Description: Arm	Part Number:	D3560-2
Inspection Dwg: D3560	Rev: B	Page 1 of 1

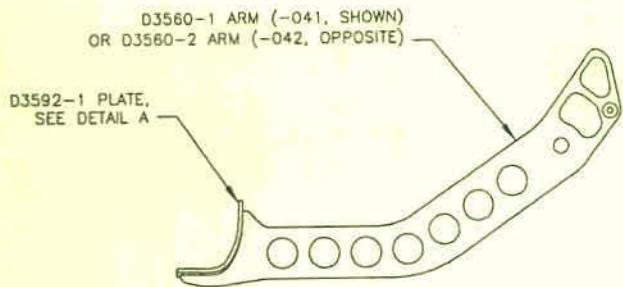
## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

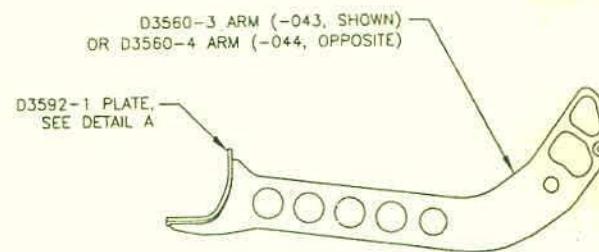
Measured by:	SL	Audited by:	SC	Prototype Approval:	N/A
Date:	04/07/21	Date:	04/07/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	EE

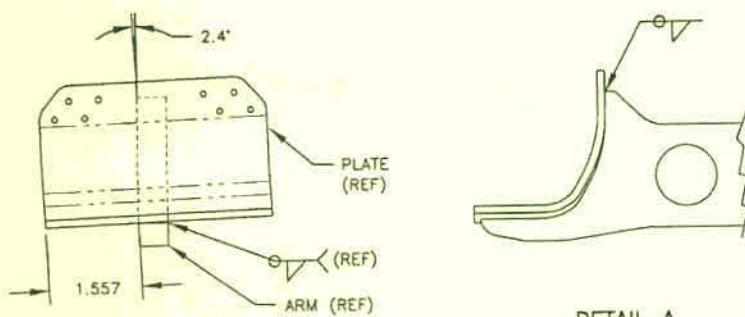




D3560-041 ARM WELDMENT (SHOWN),  
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),  
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A  
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
07.06.19

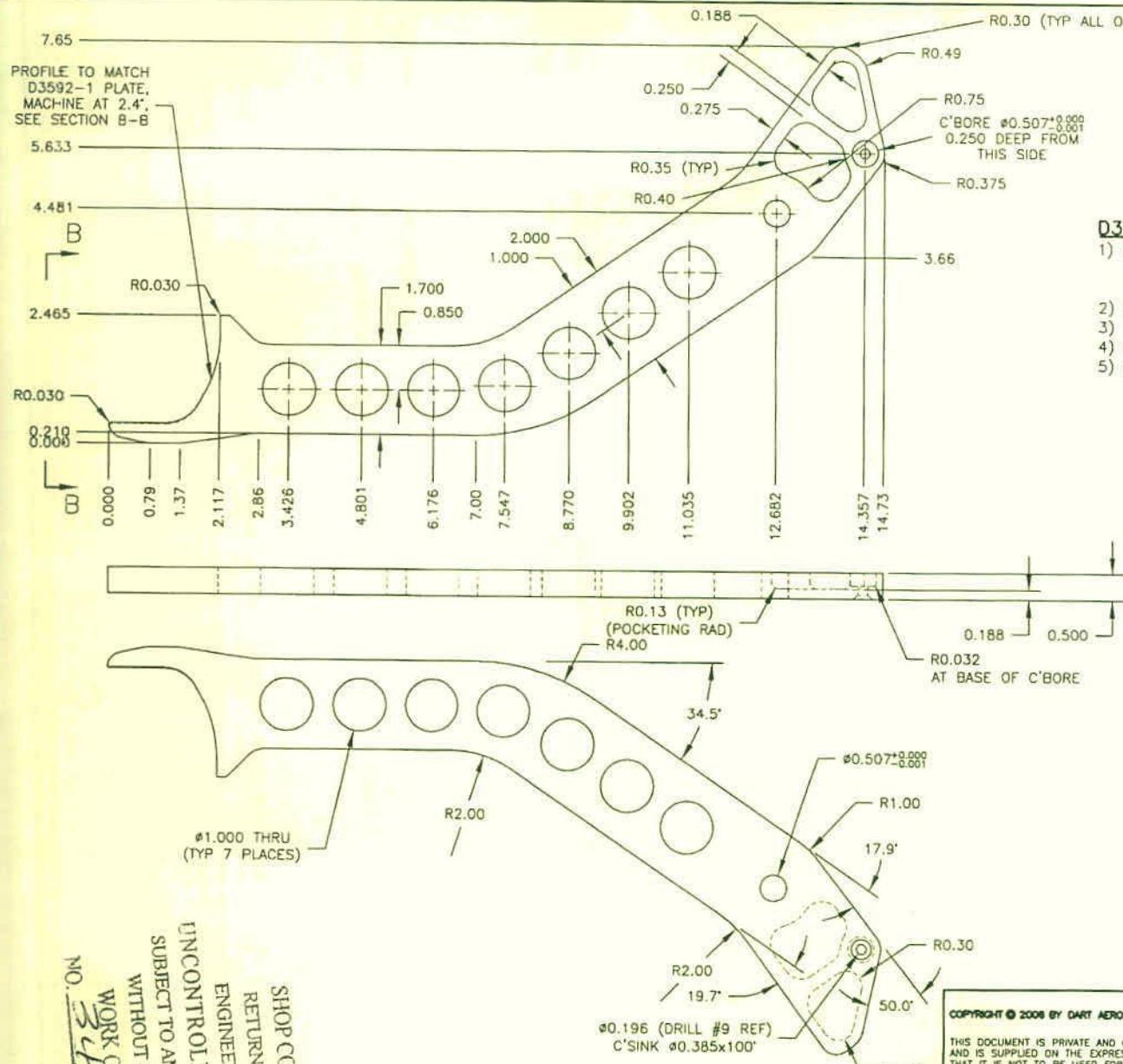
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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART
CHECKED	APPROVED	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DATE		REV. C D3560 SHEET 1 OF 3
07.06.19		TITLE ARM WELDMENT SCALE 1:1

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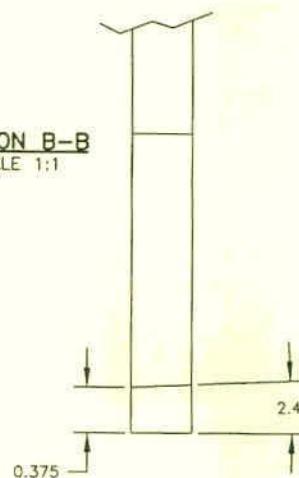




D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK  
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.  
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

**SECTION B-B**



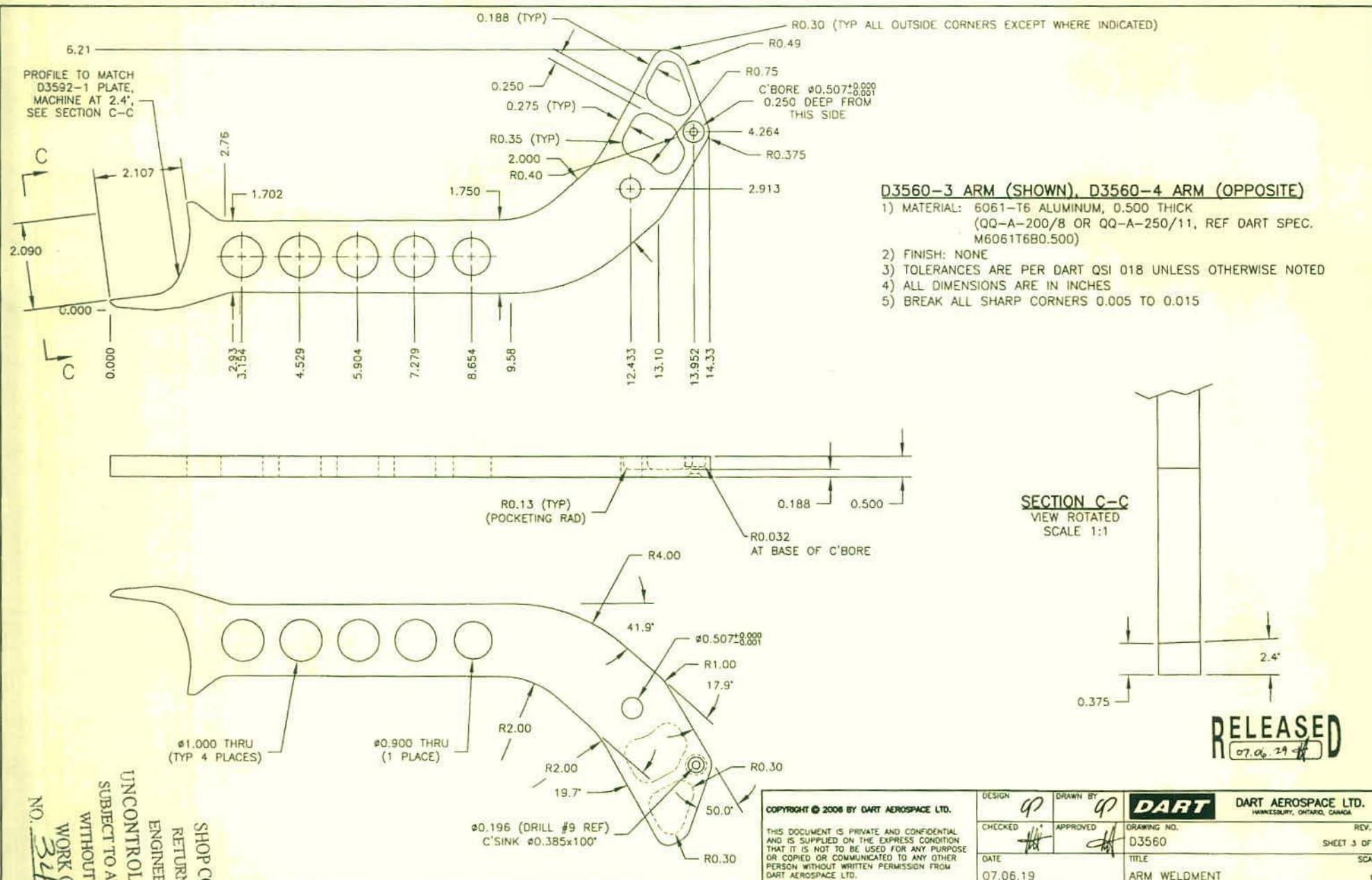
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3560	SHEET 2 OF 3
DATE	TITLE		SCALE
07.06.19	ARM WELDMENT		1:2

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